






# Work Order ID 52302

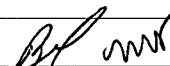


Tuesday, September 22, 2009 2:32:33 PM




Page 1

Item ID: D2884 Accept  Setup Start   
Revision ID: B Stop   
Item Name: Saddle Spacer  
Start Date: 9/23/2009 Start Qty: 40.00  Cust Item ID:  
Required Date: 10/9/2009 Req'd Qty: 40.00  Customer:

Reference:


Approvals: Process Plan:  Date: 09-9-22 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start   
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop 


Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2884	Rev B								

100  FLOW WATER JET 0.00 HB 9-10-17  
Waterjet Memo 0.00  
FLOW CNC Waterjet 1-Cut as per Dwg D2884 ☒ Dwg Rev: B ☐ Prog Rev: B ☐ 2-  
Tumble ,Deburr if necessary

Deburr m.k 09/10/19

(56)

110  QC2- Inspect parts off machine FAI/FAIB 0.00 HB 9-10-17  
QC Memo 0.00  
Quality Control

120  QC8- Inspect parts - second check 0.00 contos  
QC Memo 0.00 2) 8/21/19 (56) ✓

Quality Control

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Item ID: D2884

Accept

Setup Start

Revision ID: B

Stop

Item Name: Saddle Spacer

Start Date: 9/23/2009 Start Qty: 40.00

Cust Item ID:

Required Date: 10/9/2009 Req'd Qty: 40.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

Chemical Conversion Coat per QSI005 4.1

0.00

OK 09-10-19

56



HandFinish

Memo

0.00

Hand Finishing

140

QC3- Inspect Part Finish

0.00

MMD 09/10/19

856



QC

Memo

0.00

Quality Control

150

Identify as per dwg &amp; Stock Location: 52

0.00



Packaging

Memo

0.00

Packaging

9/10/19 565 SP

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Item ID: D2884

Accept



Setup Start



Revision ID: B

Stop



Item Name: Saddle Spacer

Start Date: 9/23/2009 Start Qty: 40.00



Cust Item ID:

Required Date: 10/9/2009 Req'd Qty: 40.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

09/10/20

MF

09-10-20

# Picklist Print

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Work Order ID: 52302



Parent Item: D2884RevB



Parent Item Name: Saddle Spacer

Start Date: 9/23/2009

Required Date: 10/9/2009

Comments:

Start Qty: 40.00

Required Qty: 40.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6S.080		Purchased	No			100	sf	110.7094	2.6568	3.7195		
6061-T6 .080 Sheet											189-10-17	

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	110.7094	
107904	0.02	
110254	2.5	
110630	38.0926	
112040	0.0437	
112141	33	
112512	37.0531	

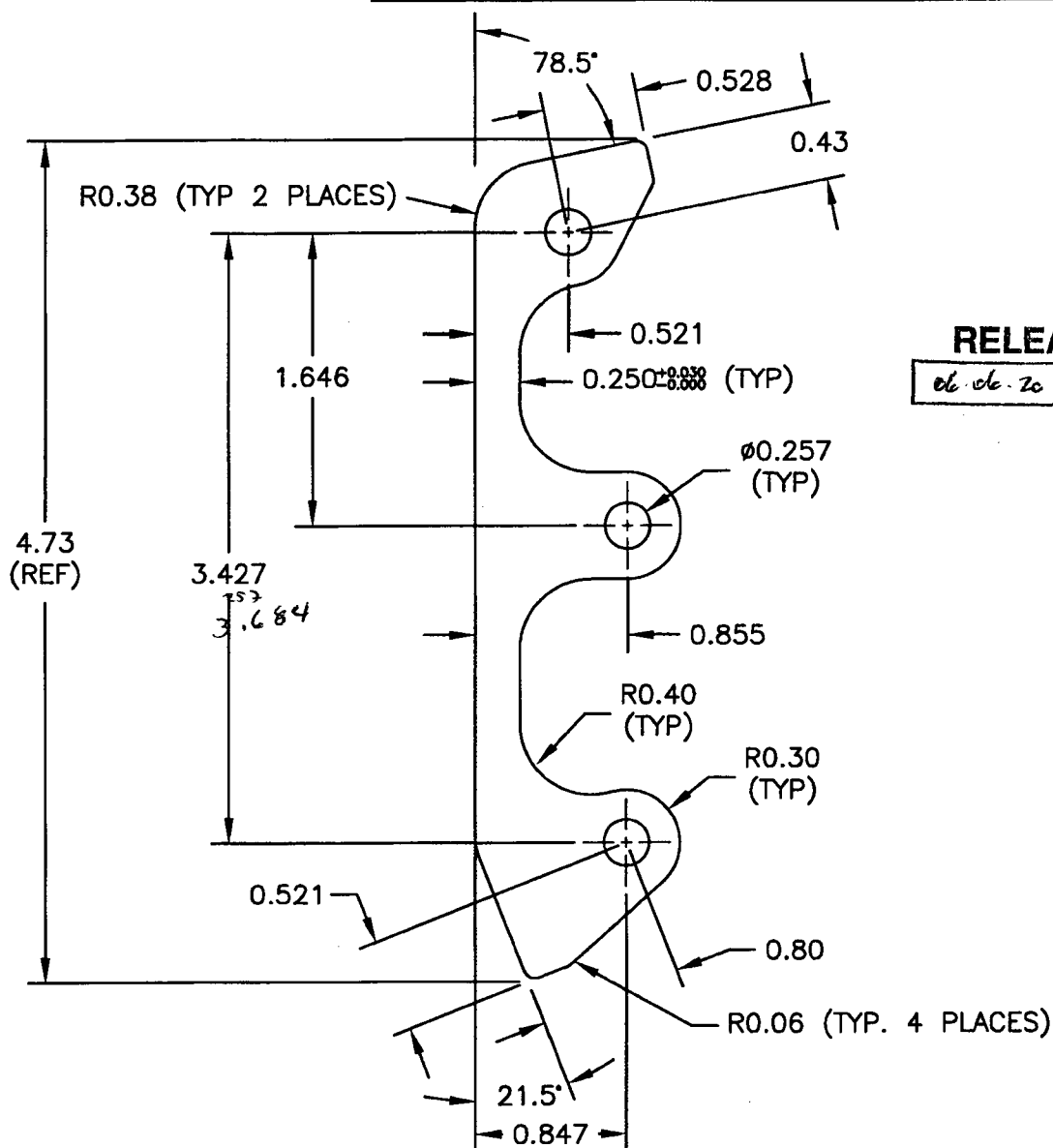
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112512

50



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT  
WITH **DART**  
WORK ORDER  
NO. 52302

DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2884	REV. B SHEET 1 OF 1
DATE 06.05.29		TITLE SADDLE SPACER	SCALE 1:1
A	99.04.01	NEW ISSUE	
B	06.05.29	ADD 6061-T6 MATERIAL	



**NOTES:**

- 1) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK (REF DART SPEC M6061T6S.080) OR 5052-H32/H34 (PER QQ-A-250/8 OR AMS 4016) 0.080" THICK (REF DART SPEC M5052H32S.080)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) ALL DIMENSIONS ARE IN INCHES

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